

Work Order ID 68241

Page 1

Monday, April 11, 2011 8:27:17 AM

Item ID: D3199-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan: HDate: 11-04-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3199

D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: PProg Rev: D

304.040

Deburr if required

11-4-11

(40)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-4-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	(1)							

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	Pto
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				39	11	04	12	(39)
130 Small Fab Small Fab Small Fab	Small Fab Memo Form as per dwg D3199 use DT9723	0.00 0.00				39				SB 11/04/12
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				11	04	13		(39)

W/O: 68241		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/04/12	120	Kept 1 part for QC template	N/A	11/04/12	1		S 11/21/12

Part No: D3199-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 4/14/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M115128.</i> Memo START TIME: <i>10:30</i> OVEN TEMPERATURE: <i>3200</i> FINISH TIME: <i>11:00</i>	0.00 0.00				<i>39.</i>		<i>BR 11-4-21.</i>	
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>N14/25</i>	<i>SP 39</i>
170 Packaging Packaging	Identify as per dwg & Stock Location: <i>236A</i> Memo	0.00 0.00						<i>11/4/25</i>	<i>SP 39</i>

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/25

11-04-28

(39)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, April 11, 2011 8:44:26 AM

Page 1

Work Order ID: 68241



Parent Item: D3199-1



Parent Item Name: Bracket



Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:C Removed Scribing 05-11-05 JLM
IPP Rev:D As per Rev B 06-11-24 JLM IPP Rev:E
11.03.31 as per ecn 11-531 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	71.4000	0.099	3.126316	4		
												RS1-4-11	

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

71.4

116437

25.4

116623

46

116623

40

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

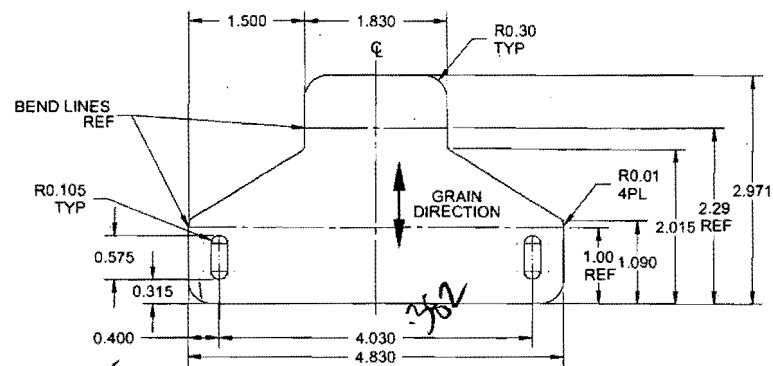
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

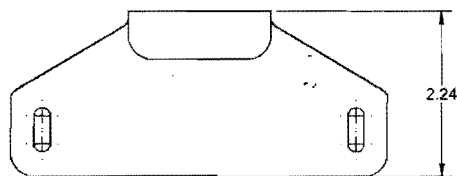
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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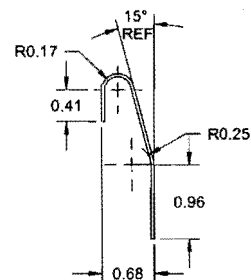
NOTE: Date & initial all entries



D3199-1F FLAT PATTERN



D3199-1 BRACKET
MADE FROM D3199-1F



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *6824*

RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDING" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

D	RE-DESIGNED D3199-3/-4-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF: PAR11-79	MB	11.03.21
C	ADD -3/-4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>49</i>		
DRAWN	<i>AS</i>		
CHECKED	<i>AS</i>		
MFG. APPR.	<i>AS</i>		
APPROVED	<i>AS</i>		
DE APPR.	<i>AS</i>		
DATE	11.03.21		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3199	REV. D
TITLE BRACKET	SCALE NTS

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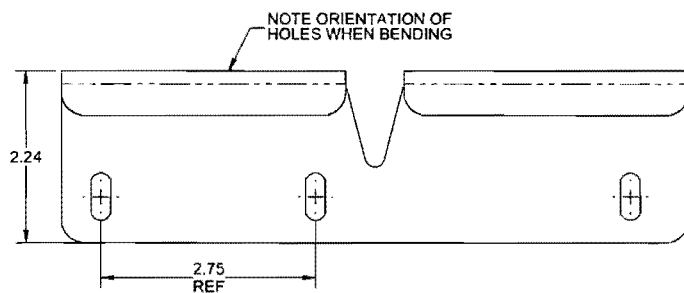
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

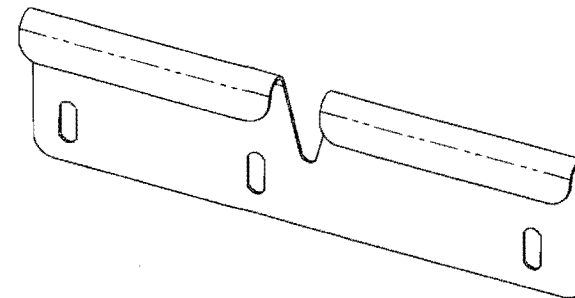
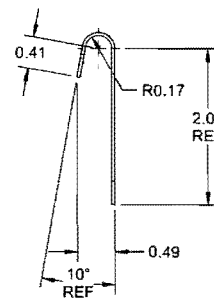
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3199-3 BRACKET
MADE FROM D3199-3F



w/o 68241

RELEASED
2011-03-31
MD

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO. D3199	REV. D
MFG. APPR.	<i>JS</i>		SHEET 2 OF 4
APPROVED	<i>JS</i>	TITLE BRACKET	SCALE
DE APPR.	<i>JS</i>		NTS
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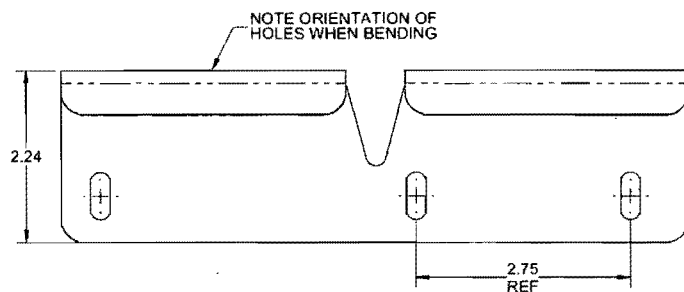
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

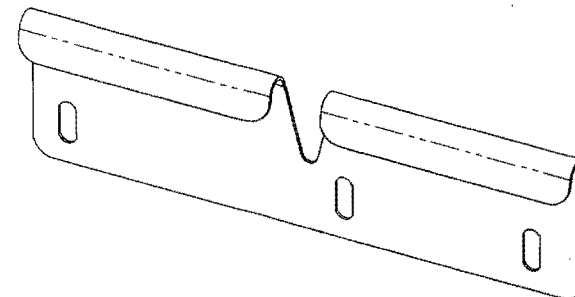
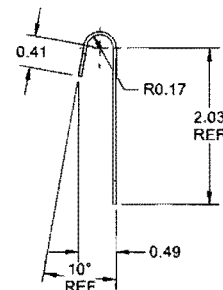
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3199-4 BRACKET
MADE FROM D3199-3F



w/o 68241

RELEASED
2011-03-31

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ALS</i>	DRAWING NO.	REV. D
MFG. APPR.		D3199	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.03.21	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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